

Split u10
8/08/01/25Date: Tuesday, 7/17/2007 2:01:50 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : N1 GEARBOX ACCESS PANEL KIT
 Job Number : 33603
 Estimate Number : 12503
 P.O. Number :
 This Issue : 7/17/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : LARGE FAB ASSY
 Previous Run : 28831
 Written By :
 Checked & Approved By :
 Comment : Est Rev: C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Part Number : D3255041
 Drawing Number : D3255 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 8/20/2007 Qty: ③ 4 Um: Each

Additional Product

Job Number:



Seq. # Machine Or Operation: Description:

1.0 D32551 Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Panel

Batch: 333605 ✓

P/L 07-11-01

2.0 D32553 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cap

Batch: M21863 ✓

P/L 07-11-01

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3255

A/R SS ROD Batch: M105138

2-Grind Welds Flush

P/L 07-11-01

4.0 DO NOT USE WELD INSPECTION



Comment: WELD INSPECTION

PD 07-11-05 (4)

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandlex (Ref: 4.3.5.6) as per Q61 005 4.3

M105642
08/01/25
07/14/06 (4)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 33603

Part Number: D3255041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



4X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-H 07/11/06

7.0

D32555

Gasket



Ph
Parker

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Gasket

Batch: 23603

SB 08/01/25 (3)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bond D3255-5 gasket to d3255-041 using Dow coming adhesive as per Dwg D3255

A/R 736

DOW CORNING ADHESIVE Batch: 1105846

08/01/25 (3)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/25 (3)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

08/01/25 (3)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/29 (3)

Job Completion

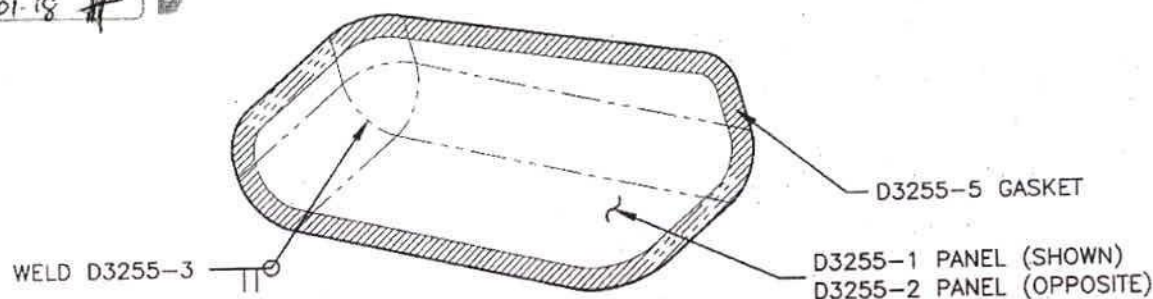


08/01/28 (3X)

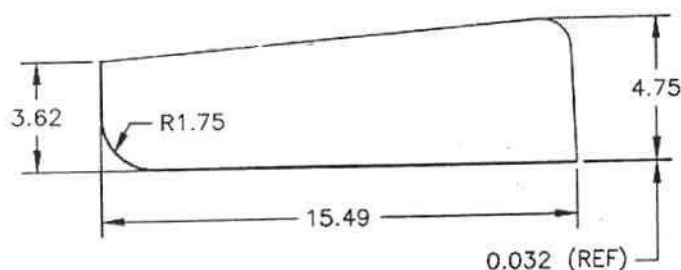
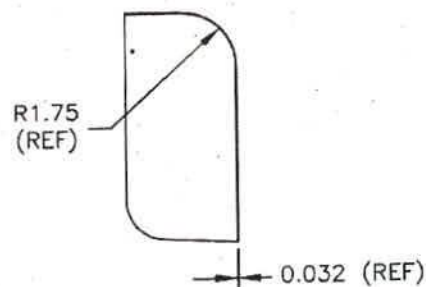
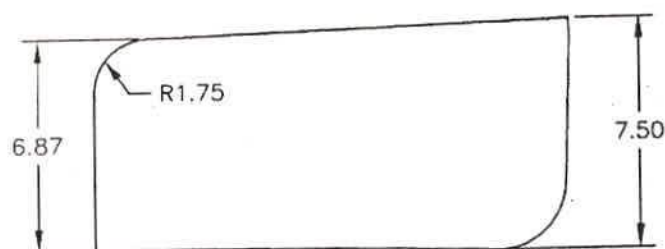


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED IP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05.01.18



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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